

Work Order ID 55545

January 20, 2010 10:00:55 AM



Page 1

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 1/20/2010 Start Qty: 2.00



Required Date: 1/21/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals: Process Plan: MF

Date: 10-1-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4021

A-PRELIM

P3

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV:

FOLIO REV:

A.P.I.

SA 10/01/21

DEBURR

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY
MF 10-1-27

2 ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/01/21

2 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55545

January 20, 2010 10:00:55 AM



Page 2

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 1/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 1/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 810/61/22

(12)

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

PD 10.01.26

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

AD. Prototype
bowl test
10.01.30

MF 10-1-27

Picklist Print

January 20, 2010 10:00:55 AM

Work Order ID: 55545



Parent Item: D4021-9



Parent Item Name: Bushing

Start Date: 1/20/2010

Required Date: 1/21/2010

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.500		Purchased	No			100	f	41.2450	0.1747			



304 SS roundbar .500

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	41.245	
108415	2	
111323	1.16	
113006	38.085	

145 SA 10/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

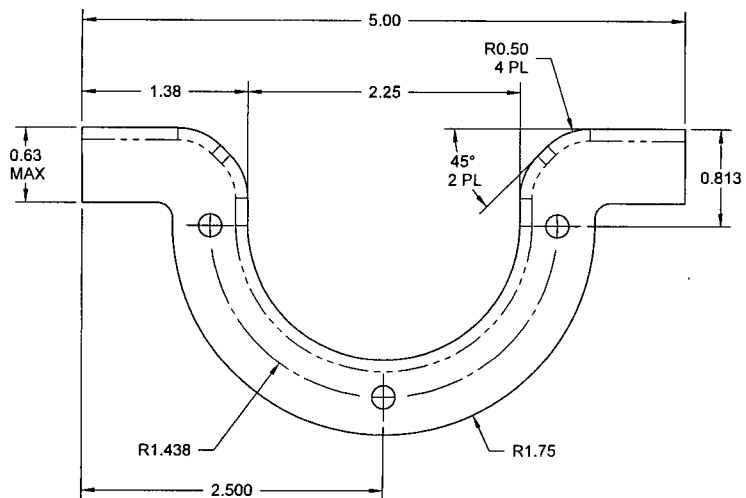
A

D

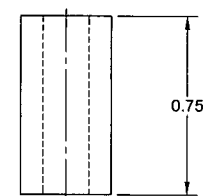
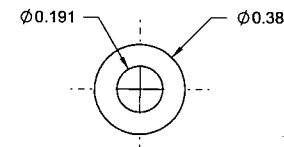
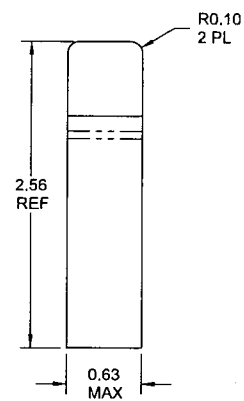
C

B

A



D4021-7 HOOP



D4021-9 BUSHING

#55545

PRELIMINARY

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs
-7: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC MACHINED PARTS 350 BASKET	NTS
DATE	09.12.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

Receiving Report

Date: 9/10/27
 Supplier: MAGNA

Batch No: M/13006

Dart P/O: 10631

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 0510128 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6063TSAU 7006063		60	63	0	0	
M304A.0500		60	625	0	3	
					250	

Production/Admin: 9/10/27
 Date
 Received/Costing [Signature]
 Initial

Initials of receiver (if shipment OK) Level 12 [Signature]

Location _____



Magna Stainless
5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I018501

RECEIVED

NOV 04 2009

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR:Y

INVOICE DATE:	10/27/09
ORDER DATE:	10/23/09
SHIP DATE:	10/27/09
ORDER NUMBER:	W020337
PURCHASE ORDER:	PO10631

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		3	PC	ALUMINUM ANGLES AAN 6063 T5 3/4" x 3/4" x 1/16" x R/L L020061 21' 3 PC/6 LB C OF C IS O.K	3 UN	10.00	30.00
		1	PC	ALUMINUM SQUARE BAR ASQ 6061 T6 2" x R/L L024300 20' 1 PC/94 LB	1 UN	220.00	220.00
		5	PC	STAINLESS ROUNDS SRB 304 1/2" x R/L L020287 12'5" 5 PC/42 LB	5 UN	25.00	125.00

10/28/09 11:02:49

Merchandise:	375.00
Surcharges:	
No Tax Costs:	
GST	18.75
Total Due:	393.75

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I018501

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO10631		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W020337	NET 30 DAYS		NIR:R-557065-1		10/23/09	10/26/09	10/26/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3 ✓		PC	ALUMINUM ANGLES AAN 6063 T5 3/4" x 3/4" x 1/16" x R/L 21' 6 LB / 3 PC C OF C IS O.K	L020061	NA	3 3
1 ✓		PC	ALUMINUM SQUARE BAR ASQ 6061 T6 2" x R/L 20' 94 LB / 1 PC	L024300	097U621	1 1
5 ✓		PC	STAINLESS ROUNDS SRB 304 1/2" x R/L 12'5" 42 LB / 5 PC	L020287	16162	5 5
Bundles: 1				Approx Weight:		142 LB

Received by: _____

Date: _____

Signature: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10631

Purchase Order Date 10/23/09

PO Print Date 10/23/09

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FXED
6063

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6063T5A0.750W.063	Angle6063T5 .750 X.750 X.063w	10/27/09	60.00	Yours ppd	\$0.5000	\$30.00
POSITIVE RECALL			Yes	f Mc 63 LC			
EFFECTIVE <u>09.10.27</u> AUTH <u>LC</u>							
RELEASED <u>LC</u> DATE <u>09.10.28</u>			Special Inst:	CFC OFFER ONLY			
2	M304R.500	304 SS roundbar .500	10/27/09	60.00	Yours ppd	\$2.0833	\$125.00
			Yes	f Mc 62.5 LC			
			Special Inst:	MATERIAL: AISI 304/316 STAINLESS STEEL ROD NOTE: AISI 303 NOT ACCEPTABLE			
3	M6061T6B2.000X02.000	6061-T6 Bar 2.00 x 2.00	10/27/09	20.00	Yours ppd	\$11.0000	\$220.00
			Yes	f P 09/10/27			
			Special Inst:	MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR PER 4117/4128/4115/4116 OR QQ-A- 200/8 OR AMS 4160 OR ASTM B221 OR ASTM B221			

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

PO Total:

\$375.00

Change Nbr: 1

Change Date: 10/23/09

No substitution or deviation without
consent.
Certificate of Conformance or Material
Certification required when applicable

10 IMPERIAL CHAMBERS, FIRST FLOOR,
WILSON ROAD BALLARD ESTATE MUMBAI
400 038 INDIA,

CUSTOMER :

MAGNA STAINLESS INC (DIV OF CANADIAN
SPECIALTY METALS INC.)
525 MELOCHE AVE. DORVAL
QUEBEC CANADA H9P 2W2

INSPECTION CERTIFICATE

ORDER NO .
075646-AD1

PACKING LIST NO. INSPECTION NO
IMP/100885 IMP/100885/5

DATE
22/09/2008

BUNDLE NO .

2715614,2715623,2715684,2715685,2715686,2715719,2715728,2715750

GRADE
T-304

DESCRIPTION :

STAINLESS STEEL BRIGHT BARS L/C NO.: I700298 DT.: 26/09/2008

COLD DRAWN POLISHED

SIZE (INC)	SHAPE	TOLERANCE	LENGTH (FT)	PIECES	WEIGHT (LBS)
1/2	ROUND	ASTM A484	12' R/L	1083	8870

CHEMICAL ANALYSIS

HEAT NO.	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N	Co
16162	0.031	1.44	0.41	0.020	0.033	8.06	18.20	0.27	0.50	0.052	0.12

TEST RESULT

.2% YIELD STRENGTH KSI	TENSILE STRENGTH KSI	ELONGATION %	REDUCTION OF AREA %	HARDNESS BHN	GRAIN SIZE
93	109	42	72	221	7

Specification :

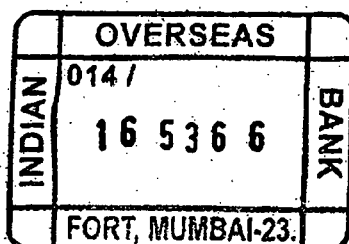
MATERIAL CONFIRMS TO ASTM A276-06 COND "A" TYPE 304, ASTM A 262-02A PRACTICE E, ASTM E 112-88(GRAIN SIZE). CERTIFICATION AS PER EN 10204-3.1.

OK 05.10.28

Remarks :

MATERIAL IS FREE MERCURY CONTAMINATION, FREE FROM WELD OR WELD REPAIRS, MINIMUM SOLUTION ANNEALING TEMPERATURE IS 1050 DEGREE
CENTIGRADE. SOAKING TIME: 1 HR / INCH. WATER QUINCHED. MICRO: FREE FROM CONTINUOUS CARBIDE NETWORK ON GRAIN BOUNDARIES, MACRO: GOOD.
COUNTRY OF ORIGIN: INDIA

We hereby certified that the material described above has been tested and complies with the terms of order/contract.



S. Suvarna
WORKS INSPECTOR
S. SUVARNA

2017340

CUSTOMER ORDER NO.: 60479
CUSTOMER PART NO.: 3-2000



MILL TEST REPORT


CUSTOMER: EXTRUDEX ALUMINUM (QUE) S.E.C.
MAGNA STAINLESS INC. 5775 RUE KIERAN
SAINT - LAURENT, QB H4S 0A3

SAMPLE (S) OF ALUMINUM

REPORT: 66208

DIE NO. S-3132
DESCRIPTION 2" SQ BAR
AL. ALLOY & TEMPER. 6061/T6
EXTRUDEX ORDER NO. 110991-10-A.11
SPECIFICATION ASTM B221
SILICON % 0.62
IRON % 0.16
COPPER % 0.20
MANGANESE % 0.02
MAGNESIUM % 0.87
CHROMIUM % 0.06
ZINC % <0.01
TITANIUM % 0.02
ALUMINUM % REMAINDER
ALLOY TYPE % 6061
ALLOY CAST NO. 0970621
YIELD STRENGTH (IN ksi) 39.7
TENSILE STRENGTH (IN ksi) 43.1
ELONGATION % IN 2" 15.3
HARDNESS (ROCKWELL 'F') 88.8
88.9
88.1

8
02/06/28


F. TABING
(LAB. TECH.)
DATE: MAR-23-09

**MAGNA
INOXYDABLE INC.**

1
(613)

FAX #: 632-1053

DATE: 10/28/09

PAGES: 1 + COVER
+ COUVERTURE

E-MAIL: bmartin@magnastainless.com


5775 Rue Kieran St-Laurent Quebec H4S 0A3 TEL: (514) 339-1211 1 (800) 363-6646

**MAGNA INOXYDABLE
INC.**5775 RUE KIERAN
ST-LAURENT, QUEBEC
H4S 0A3 (514) 339-1211, 1-800-363-6646**CERTIFICAT DE CONFORMITE
CERTIFICATE OF CONFORMANCE****DATE: 10/23/09****COMPAGNIE / DART AEROSPACE LTD
COMPANY:****VOTRE/YOUR #: PO 10631****ORDER DATE/
DATE DU COMMANDE: 10/26/09****NOTRE / OUR #: I018501**

<u>DESCRIPTION</u>		<u>QUANTITE/QUANTITY</u>	<u>SPECIFICATIONS</u>
TYPE:	6063 T5	3 PCS	
SIZE:	3/4 X 3/4 X 1/16 X 21'		
HEAT #:	N/A		

Magna Stainless certifie que le matériel décrit ci-dessus, s'accorde aux dessins ou aux spécifications demandées sur le bon de commande et qui sont en vigueur à la date ou la commande est acceptée.

Magna Stainless certifies that the material described above is in accordance with the drawing or specifications called for on said order that is current on the date order was accepted.

Signed: Barry Mart 

MAGNA LOG # L020061

JP
09.10.28

Chantal Lavoie

From: Eryck Blais [eblais@magnastainless.com]
Sent: October 22, 2009 11:08 AM
To: 'Chantal Lavoie'
Subject: RE: quote

HI CHANTAL

ALL STOCK CAN DEL'D ON MONDAY AND THE 3/16" X 4" WILL BE THERE ON MONDAY TO.
THANK YOU
ERYCK

From: Chantal Lavoie [mailto:clavoie@dartaero.com]
Sent: Thursday, October 22, 2009 10:57 AM
To: Eryck Blais
Subject: quote

Please advise price & delivery on material.

6063t5 angle .750" x .750" x .063 wall x 60 ft 3 PCS \$ 10.00 EACH CAN ONLY OFFER CFC NO MILTEST

304 round bar .500" x 60 ft 5 PCS 25.00 EACH

6061t6 bar 2" x 2" x 12ft 1 PC 20' \$220.00 EACH

Thanks

Chantal

10/22/09

D2258-220RevC	1	0	20	10
D2258-300RevC	1	0	3	0
D2329RevB	1	0	12	0
D2404RevA	1	0	0	0
D2729-1RevU/R	1	0	0	0
D2985RevA1	1	0	19	4
D3144-105FRevC	1	0	0	0
D3186-2PRevD	1	0	0	0
D3482-11RevB	1	0	9	2
D3482-13RevB	1	0	17	2
D3482-1RevB	1	0	5	2
D3482-3RevB	1	0	7	2
D3482-5RevB	1	0	7	2
D3482-9RevB	1	0	7	2
D3483-1RevA	1	0	8	2
D3483-3RevA	1	0	10	2
D3579-048RevC	1	0	3	6
D3721-2RevA	1	0	6	4
D3755-041RevB	1	0	2	1
D3756-041RevB	1	0	2	1
D3810-1RevA	1	0	3	2
D412-711-041RevN/A	1	0	0	0
HA000611	1	0	29	0
M6061T6A.750W0.625	1	0	0	6
MS21209C6-10	1	0	24	20
MS21919-DG48	1	0	10	4
MS24166-D1	1	0	2	1
MS25244-15	1	0	5	0
MS25244-75	1	0	5	2
MS35058-22	1	0	2	1
PR-71	1	0	0	20
	0.89649473		13.3258631	
M6061T6B2.000X02.000	7	0	6	12
MPA1/80324X10B	0.886	0	43	0
M1010B0.375X03.500	0.78	0	15	12
M1010R0.375	0.56	0	12	0
	0.36842105			
M6061T6R3.500	3	0	15	12
	0.31574736			
M304R.250	8	0	23.4328	24
M6061T6B0.750X01.500	0.30798054	0	17.2764	12
	0.30625789			
D3195RevA	5	0	114.7031	100
M6061T6B1.000X02.500	8.08E-02	0	17.325	12
M304S13GA	3.16E-02	0	32	8
M6061T6B0.500X01.000	2.11E-03	0	24.7079	10
M303R0.375	4.21E-04	0	24.04	12
627-867	2.00E-04	0	12	6
M6061T6B0.250X06.000	3.16E-05	0	11.2674	12

	7.73684210			
D3800-1-200RevB	5	0	9	4
	7.43094736			
M5052H32S.040	8	0	60.76	64
	7.15789473			
MDELRLNB1.000X04.000	7	0	26	40
	7.01060526			
M304TR0.675W.091	3	0	72.3085	60
18-200	7	-2	7	20
D3755-041P	7	0	0	0
D3756-041P	7	0	0	0
D6008-132PRevA	7	0	0	0
M81714/16-3	7	0	5	4
M81714/2-DD2	7	0	4	4
M83536/2-024	7	0	13	4
MS28778-6	7	0	0	20
	6.03157894			
M304R.500	7	0	9.2	6
	6.03157894			
M304TR0.375W.035	7	0	80	12
AN815-4J	6	0	20	6
AN8C35A	6	0	149	50
AS1035J080812	6	0	10	6
D2856-100-250RevA	6	0	0	0
D3031-1RevA	6	0	17	5
D3108-5RevB1	6	0	3	0
D3383-1RevA	6	0	13	0
D3753-1P	6	0	6	0
D3754-1P	6	0	6	0
MS124738	6	0	8	6
MS24694-S46	6	0	91	0
MS27039-1-11	6	0	95	10
QS200-44S	6	0	41	0
M6061T6T0.375W.058	5.96	0	92.61	100
	5.92944901			
M303R0.500	1	0	72.2673648	20
M6061T6B2.500X03.500	5.6775	0	26.2675	20
M304R1.250	5.332	0	73.5	20
D2854RevA	5.298	0	257.3	40
	5.26315789			
M1010B1.000X02.000	5	0	9.06	6
A1449	5	0	1214	95
AN960-4L	5	0	866	20
AN960JD416L	5	-2	880	100
BLRS-001	5	0	3	2
CR3223-4-3	5	0	103	50
D3802-1RevB	5	0	55	0
MS27039C1-09	5	0	30	10
	4.70060526			
M6061T6B1.000X02.000	3	0	84.0545	60
	4.56863157			
M6061T6B1.000X04.000	9	0	74.3	6

	8			
AN5C32A	52	0	106	100
CR3212-4-03	52	0	300	100
D2732-030RevB1	52	0	0	0
MS27039-1-06	52	0	968	20
	51.0526315			
M6063T5A0.750W:063-100	8	0	37.84	6
D2646PRevC	50	0	0	0
D2965PRevB	50	0	0	0
	48.5936842			
M4130NB0.500X03.000	1	0	80.74	40
AN4C52A	48	0	156	200
AN526C632R8	48	0	312	50
AN6C12A	48	0	171	100
AN960C4	48	0	108	50
AN960C616L	48	0	120	100
D3631-1RevA	48	0	261	20
D3672-9RevB	48	0	563	40
D3683-1RevA	48	0	4430	10
D3683-3RevB	48	0	0	0
MS20601-AD4W4	48	0	47	10
MS21073L4	48	0	126	10
MS27039C1-05	48	0	263	100
NAS9307/M-4-03	48	0	314	6
AN3C3A	47	0	513	200
NAS1611-010	47	0	338	200
	46.6576789			
D2462RevA1	5	-50	773.8344	50
	45.8964578			
M6061T6B00750X00.125	9	0	45.2293	80
	45.3052631			
M6061T6B0.500X05.000	6	0	157.4	12
MS25036-102	45	0	75	50
	44.0266157		170.703984	
D2461RevA	9	0	2	50
MS20426AD4-4	44	-2	3208	3030
MS21920-28	44	-6	170	0
PFSC35-38A	44	0	98	0
AN6-36A	42	0	105	50
AN6C44A	42	0	150	100
D3456-1RevA	42	0	187	20
MS20426AD3-5	42	0	15965	3704
MS21043-6	42	0	1060	500
AN5C13A	41	0	100	100
AN6-40A	41	0	108	50
	40.4131421			
D2732RevB1	1	-47.8333	89.073	50
086-004	40	0	25	0
AN3C7A	40	0	289	200
AN4-11A	40	0	630	400
C23225	40	0	0	0
D2731-3PRevB	40	0	0	0

Work Order ID 51403

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Item ID: D212-722-011

Revision ID: C

Item Name: Avionics Console

Start Date: 8/21/09 Start Qty: 4.00

Required Date: 9/07/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *CZ*

Date: *09/02/09* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3363	Rev C
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

REFERENCE ONLY

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg.
D3360 Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall 12-Cut (1)
D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel
3/4" x 3/4" x 0.125" wall 3-Debur D3360-1/-

120

Chemical Conversion Coat per QS1005.4.1

0.00



Hand Finish

Memo

0.00

Hand Finishing

M 6063T5A.0750 W. 063